

DART AEROSPACE LTD		Work Order:	22740
Description: D2306 rework as a D2304		Part Number:	02304
Dwg:		Qty:	1
			Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	dkj	05.04.22	1
2	QC	Remove D2306 B# 4277 from stores	AB	05.03.15	1
3	GA	Rework D2317 / D2342 from D2306	AB	05.03.16	1
4a	GA	Rework D2303 as per Dwg D2319	AB	05.03.16	1
5	GA	Rework D2302 as per Dwg D2313	AB	05.03.16	1
6	QCS	Inspect level 5	TT	05.04.18	1
7	FP	Reassemble (Cat) as per QSI 005	AB	05.04.18	1
8	QC3	Inspect level 3	U	05.04.21	1
9	ST	Ident, Sg and stock as D2304 B# 22740	U	05.04.21	1
4b	GA	Install rivet ^{act} PMS 20126 AD4-41 H#1021 AB	05.03.16		1
10	AC	C close 393.35	54C	05.04.22	1
10	DC	Close w/o inspect level 21	dkj	05.04.22	1

Rev	Date	Change		Revised By	Approved
A		New issue	!		

IPP- Batch No: 4277

DESCRIPTION: 204 Aspirator Assembly

Part No: D230X

Qty: 4

Dng D2306 incl.

75.20

MANUFACTURER RELEASE CERTIFICATION

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

~~Authorized Inspector~~

~~Approved~~
Authorized Inspector

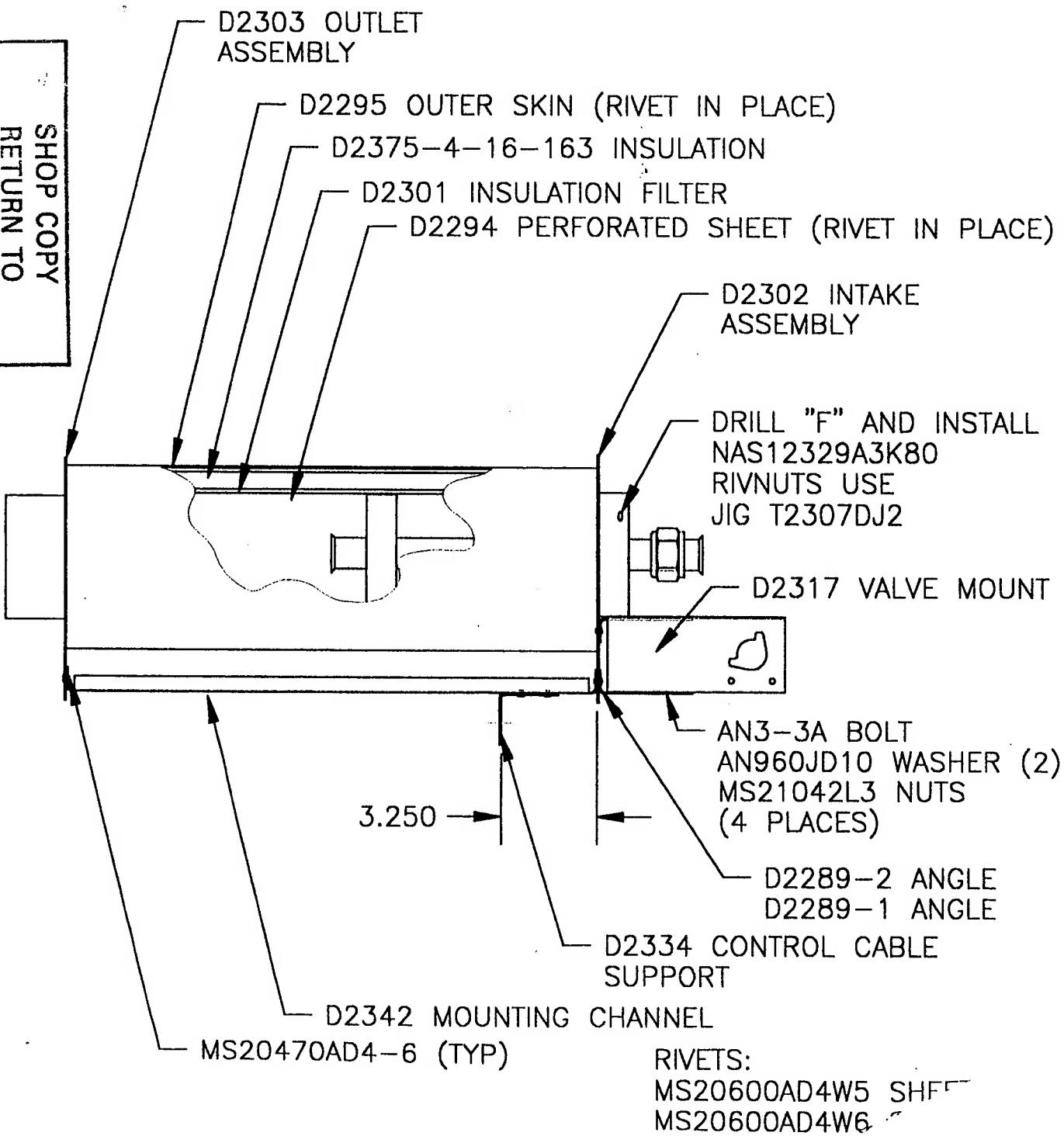
16/08/30

Date _____

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RETURN TO
ENGINEERING

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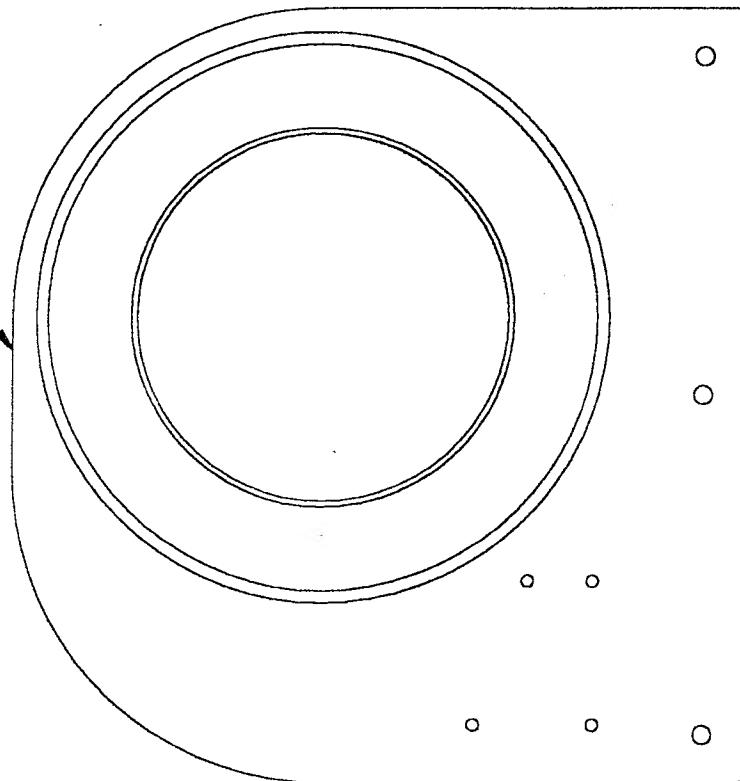
DATE 95.01.03
TITLE B204 ASPIRATOR ASSEMBLY



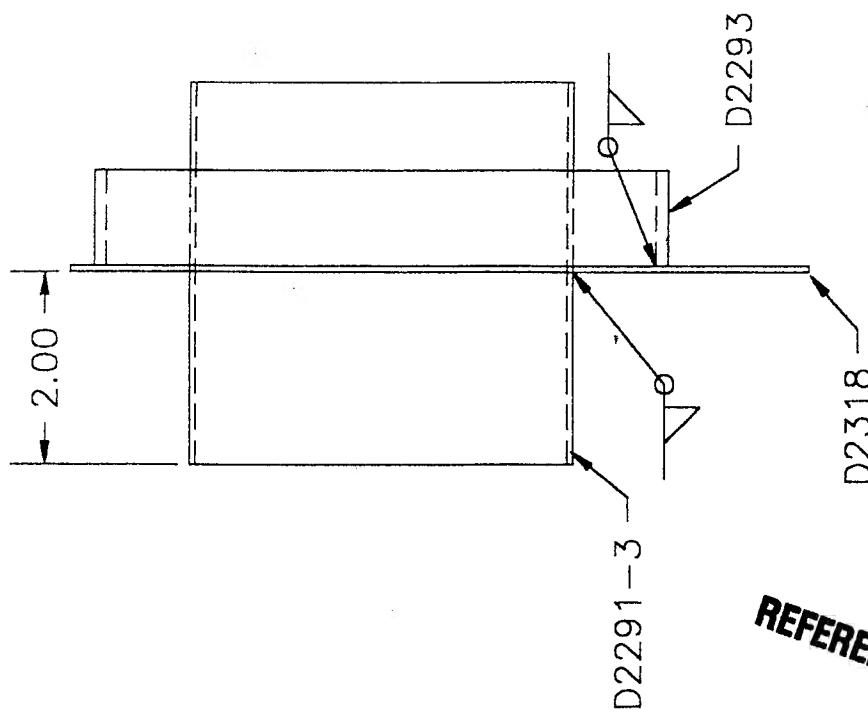
CONTROLLED COPYCOPY ISSUE
G

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2303	REV. C	SHEET 2 OF 2
DATE 94.11.02		TITLE OUTLET WELDMENT ASSEMBLY		SCALE

D2318



FINISH: ANODIZE

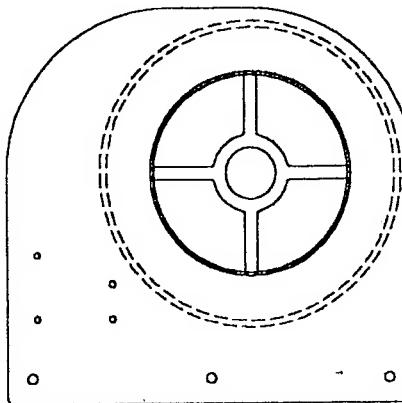


GUNNAR HOLMÉN

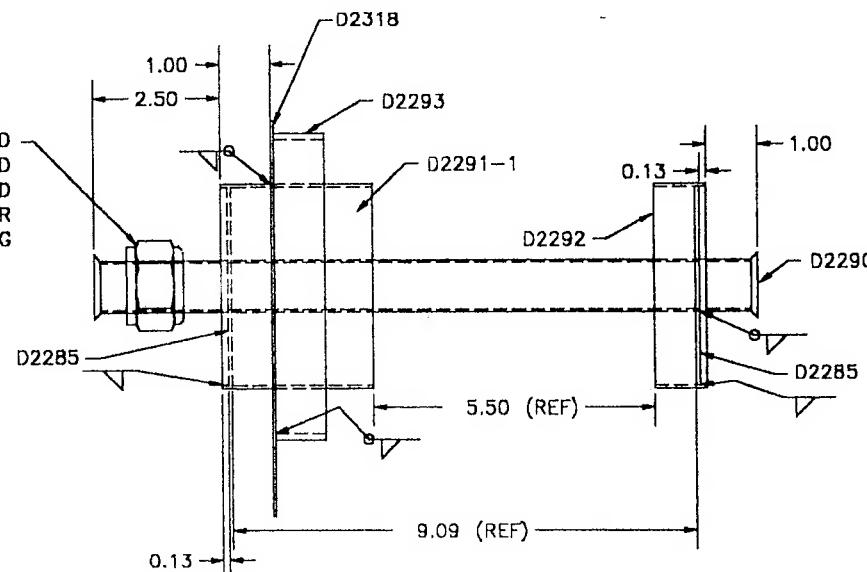
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
<i>B.L.S.</i>	<i>S.W.</i>	D2302	SHEET 2 OF 2
DATE	TITLE	SCALE	
94.10.25	INTAKE WELDMENT ASSEMBLY		

REFERENCE ONLY



**AN818-16D
MS20819-16D
INSTALL AND
FLARE AFTER
ANODIZING**



FINISH: ANODIZE

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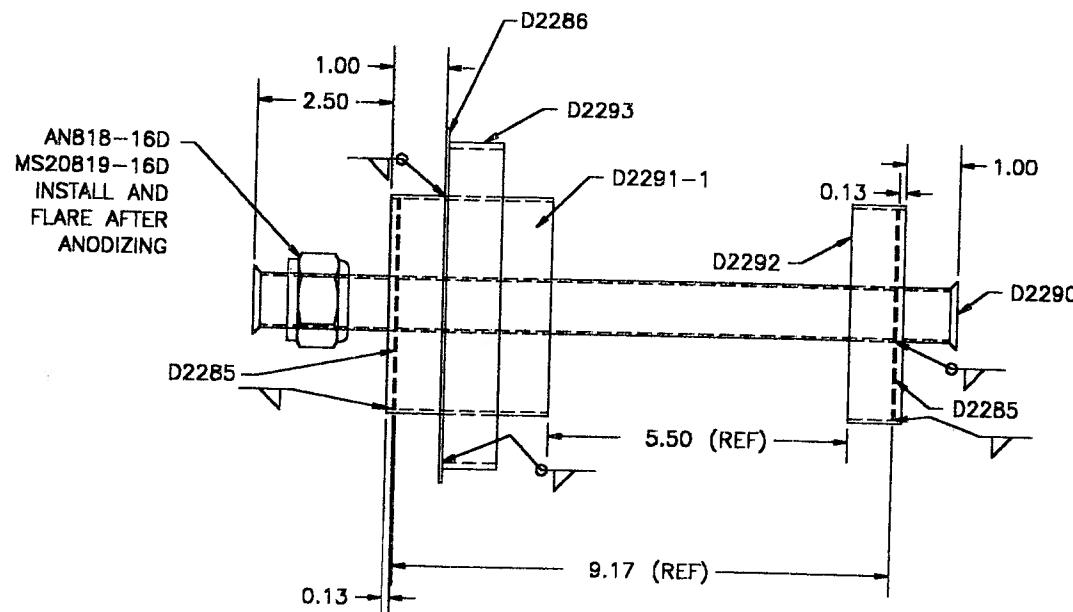
PREPARED		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA
B. Williams		
CHECKED	APPROVED	
DATE		TITLE
Jan. 10, 1995		INLET WELDMENT ASSEMBLY
D	96:04:18	SCALE MODIFIED MASTER PARTS LIST

QTY	Part No.	Description
X	D2313	INTAKE WELDMENT ASSEMBLY
2	D2285	LOCATOR CROSS
1	D2289	END PLATE
1	D2290	JET PIPE
1	D2291-1	4" RING
1	D2292	4" RING
1	D2293	6" RING
1	AN818-16D	FLARE NUT
1	MS20819-16D	SLEEVE

DART

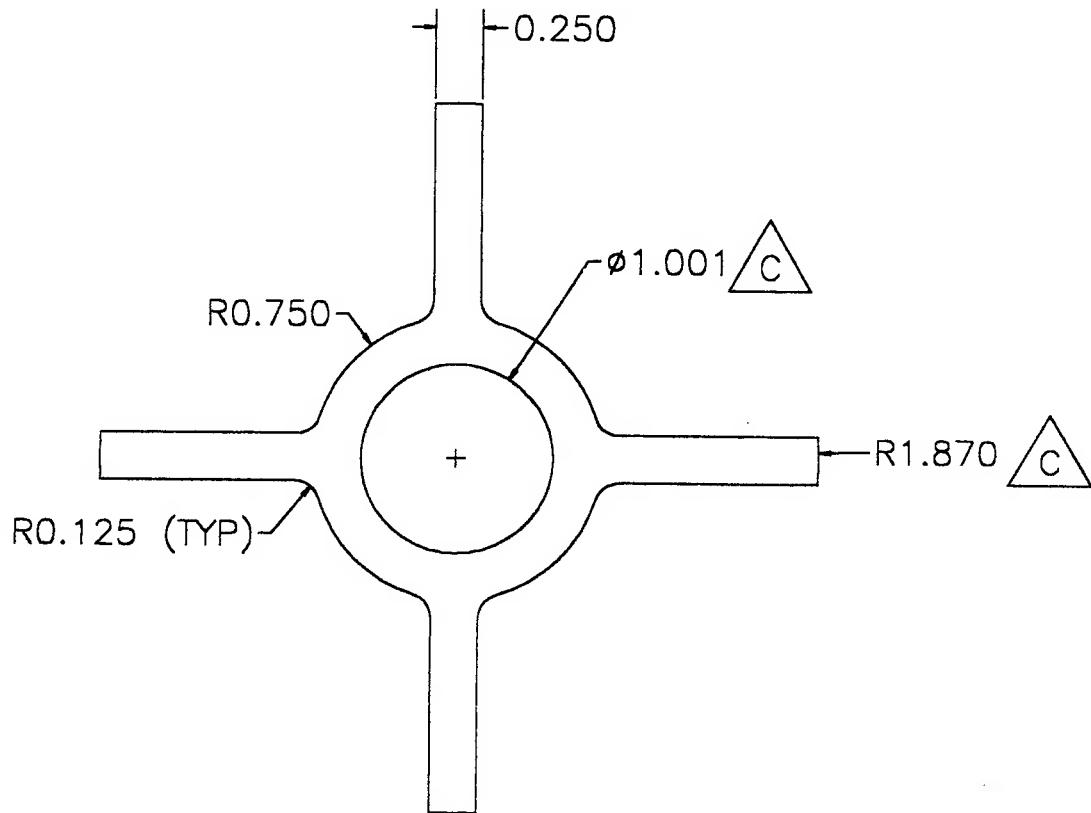


PREPARED	B. Williams	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	(Signature)	APPROVED
DATE	Jan. 10, 1995	REV. D SHEET 2 OF 2 SCALE
TITLE		INLET WELDMENT ASSEMBLY



DART

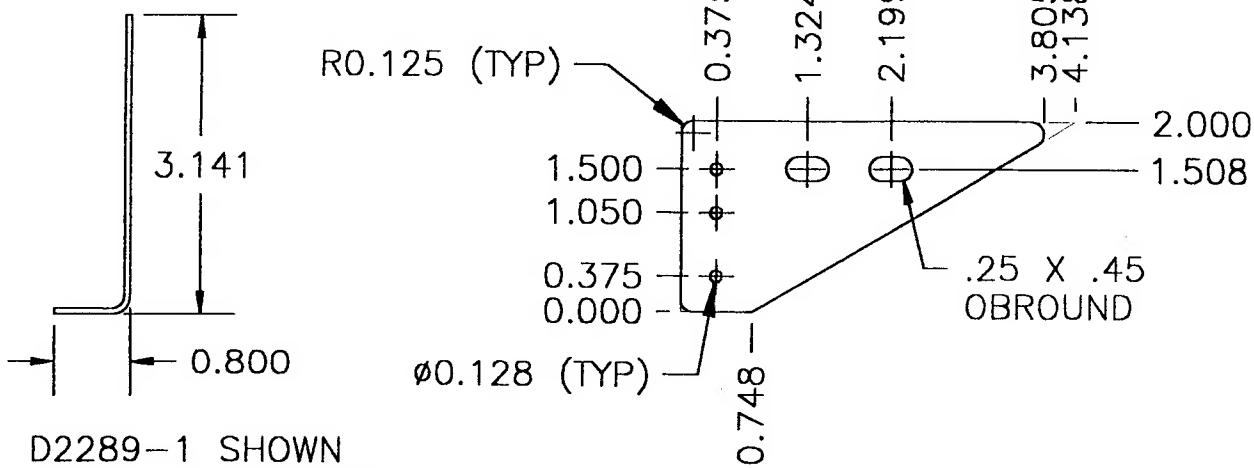
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2285	REV. C SHEET 1 OF 1
DATE 94.21.21		TITLE HEATER TUBE LOCATOR	SCALE 1:1
B	Nov. 7, 1994	CHANGED ARM ENDS	
C	96.01.15	CHANGED DIMENSIONS	



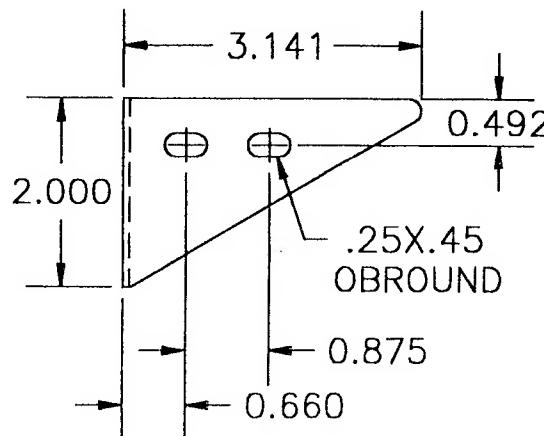
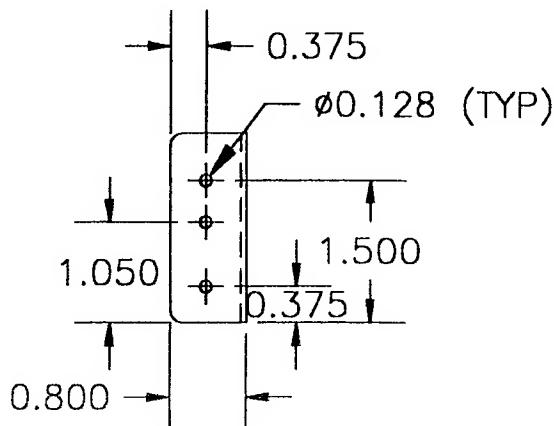
MATERIAL: 5052-H34 0.080 THICK

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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHEKED <i>B</i>	APPROVED <i>RS</i>	DRAWING NO. D2289
DATE 94.12.21		SCALE 1:2
C	96.01.15	TITLE VALVE MOUNTING BRACKET



D2289-1 SHOWN
D2289-2 OPPOSITE

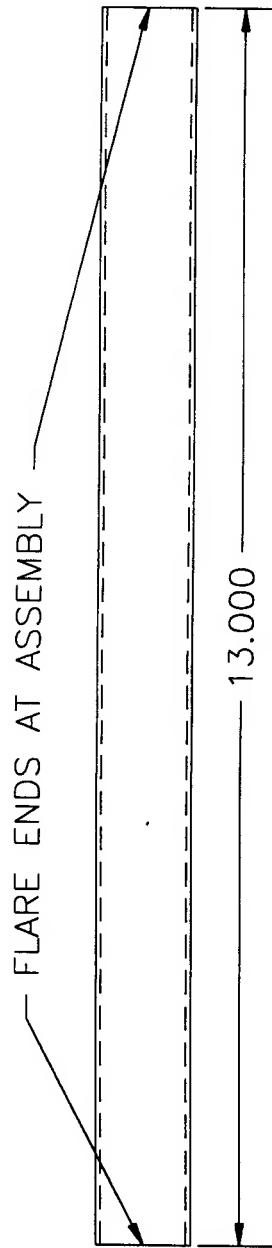


BEND RADIUS: 0.125
MATERIAL: 5052-H34 0.063 THICK



COPY
CENSUS

PREPARED		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA
B. Williams	APPROVED	REV. A
CHECKED		SHEET 1 OF 1
DATE	D2290	
Oct. 25, 1994	TITLE 1" HEATER TUBE	



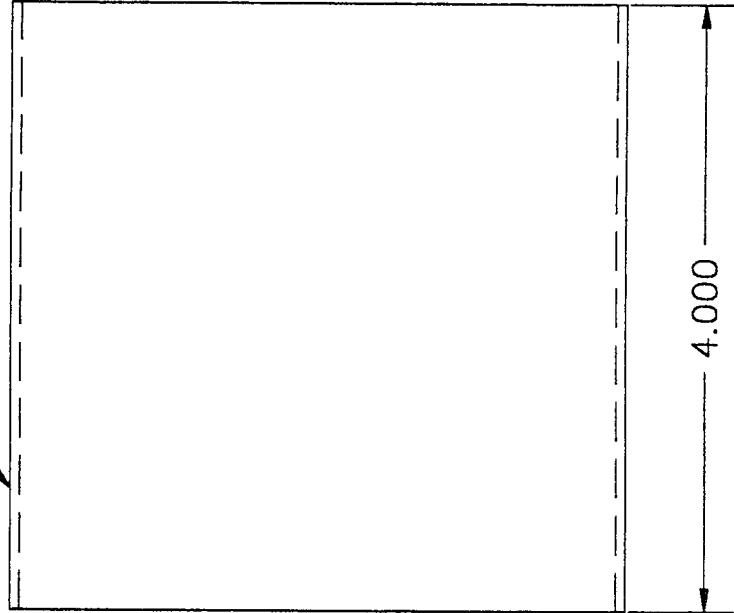
~~12'~~
~~12.50 ft.~~
~~195/ft.~~

MATERIAL: 6061-T6 SEAMLESS TUBE
1" DIAM 0.049 WALL CUT 13" LONG

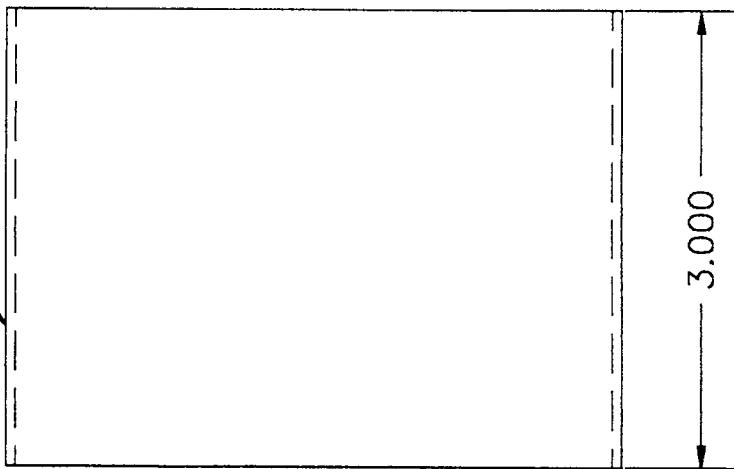
DARTQA COPY
CENSIS

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED B.W.	APPROVED B.W.	DRAWING NO. D2291
DATE 94.10.25		TITLE 4" HEATER TUBES
B	96.01.15	SCALE CHANGED MATERIAL

D2291-3



D2291-1

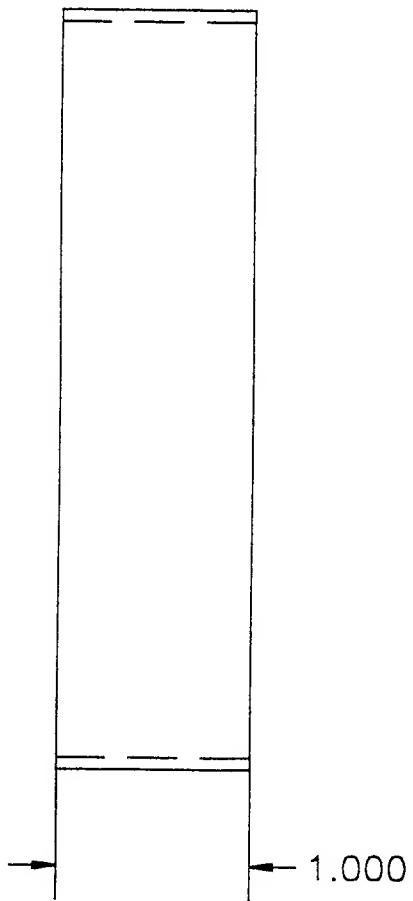


MATERIAL: 6061-T6 TUBE
4" OD X 0.125 WALL

DART



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2292	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 4" HEATER TUBE	SCALE 1:1
	B	96.01.15	MATERIAL WAS 0.063 WALL

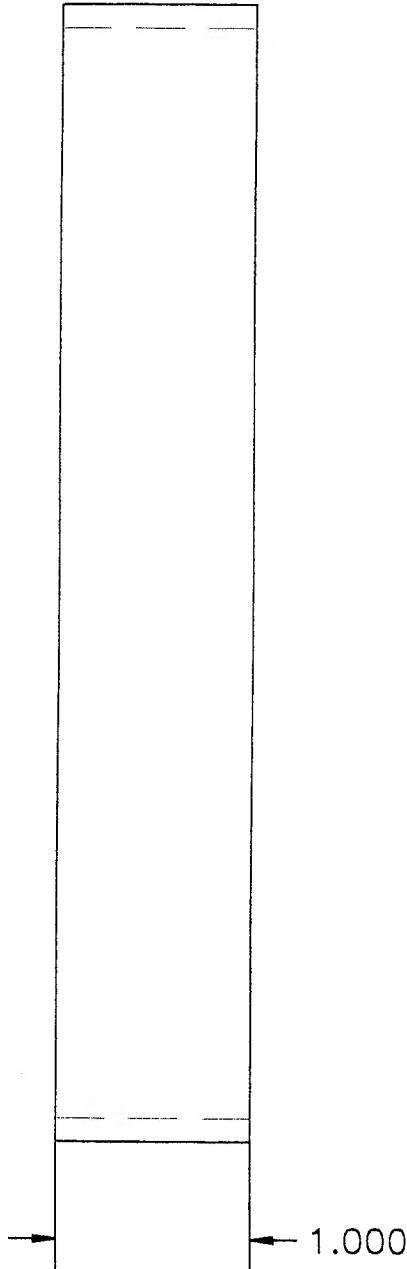


MATERIAL: 6061-T6 TUBE
4" OD X 0.125 WALL CUT 1" LONG



Q/COPY
ISSUED

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2293	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 6" HEATER TUBE	SCALE 1:1
B	96.01.15	CHANGED MATERIAL	



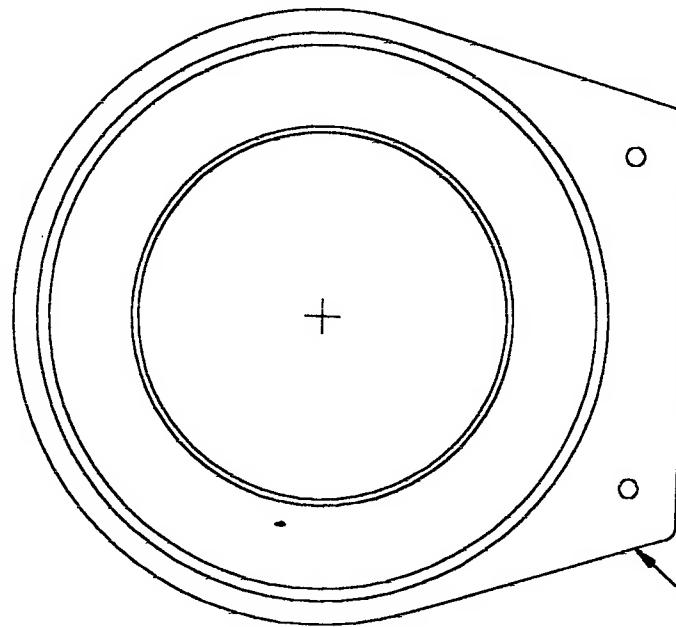
12' = 17.61 ft 23 wks
24' = 12.92 ft 1-2 wks

MATERIAL: 6061-T6 TUBE
6" DIAM 0.125 WALL CUT 1" LONG

DARTCOPY ISSUED
DATE

PREPARED	B. Williams	
CHECKED	BW	APPROVED
DATE	Jan. 10, 1995	

DART AERO ACCESSORIES INC
VICTORIA INTERNATIONAL AIRPORT, CANADA
REV. B
SHEET 2 OF 2
SCALE
TITLE
OUTLET WELDMENT ASSEMBLY



D2288

